

Work Order ID 120954

July-10-14 10:24:57 AM

120954

Page 1

Item ID: D3531-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 7/10/14 Start Qty: 10.00

10 9

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MWS

Date: 14-07-10

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3531	B								

100

0.00

100

FLOW WATER JET

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3531
Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(9)

mm

14/07/18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

Memo

0.00

QC

Quality Control

(9)

mm

14/07/18

Work Order ID 120954

120954

Page 2

July-10-14 10:24:57 AM

Item ID:	D3531-1	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:							
Item Name:	Bracket					Stop *NS2*	
Start Date:	7/10/14	Start Qty:	10.00	*10*	Cust Item ID:		
Required Date:	7/10/14	Req'd Qty:	10.00	*10*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC8- Inspect parts - second check	0.00	DAS 27 9-39			9			
	Memo	0.00	W/H/18						
130 *130* Brake NC	Bend as per dwg NC BRAKE C. SINK as per dwg	0.00	DAS 36 30 9-89			9			14/07/21
	Memo	0.00							
140 *140* QC	QCS- Inspect part completeness to step on W/O	0.00	DAS 36 30 9-89			9			
	Memo	0.00	SHP						
			W/H/21						

Work Order ID 120954

120954

Page 3

July-10-14 10:24:57 AM

Item ID: D3531-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 7/10/14 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 7/10/14 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

9 7/14/14

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

9x 7/14/14

Quality Control

170

Identify as per dwg & Stock Location G-A

0.00

170

Packaging

Memo

0.00

9x 7/14/14

Packaging

Work Order ID 120954

120954

Page 4

July-10-14 10:24:57 AM

Item ID: D3531-1 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Bracket Stop *NS2*
Start Date: 7/10/14 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 7/10/14 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC	QC21- Final Inspection - Work Order Release Quality Control	0.00							MJD 14-07-25
	Memo	0.00							JH 7-25

Picklist Print

Page 1

July-10-14 10:25:00 AM

Work Order ID: 120954

120954

Parent Item: D3531-1

D3531-1

Parent Item Name: Bracket

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	127.7900	0.3783	4		**	

M6061T6S.040

6061-T6 .040 Sheet

Location	Loc Oty	Loc Code
MAT021	127.79	
m128422	49.79	
<u>m129584</u>	78	<u>4.3</u>

DART AEROSPACE LTD	Work Order:	120959
Description: Bracket	Part Number:	D3531-1
Inspection Dwg: D3531	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

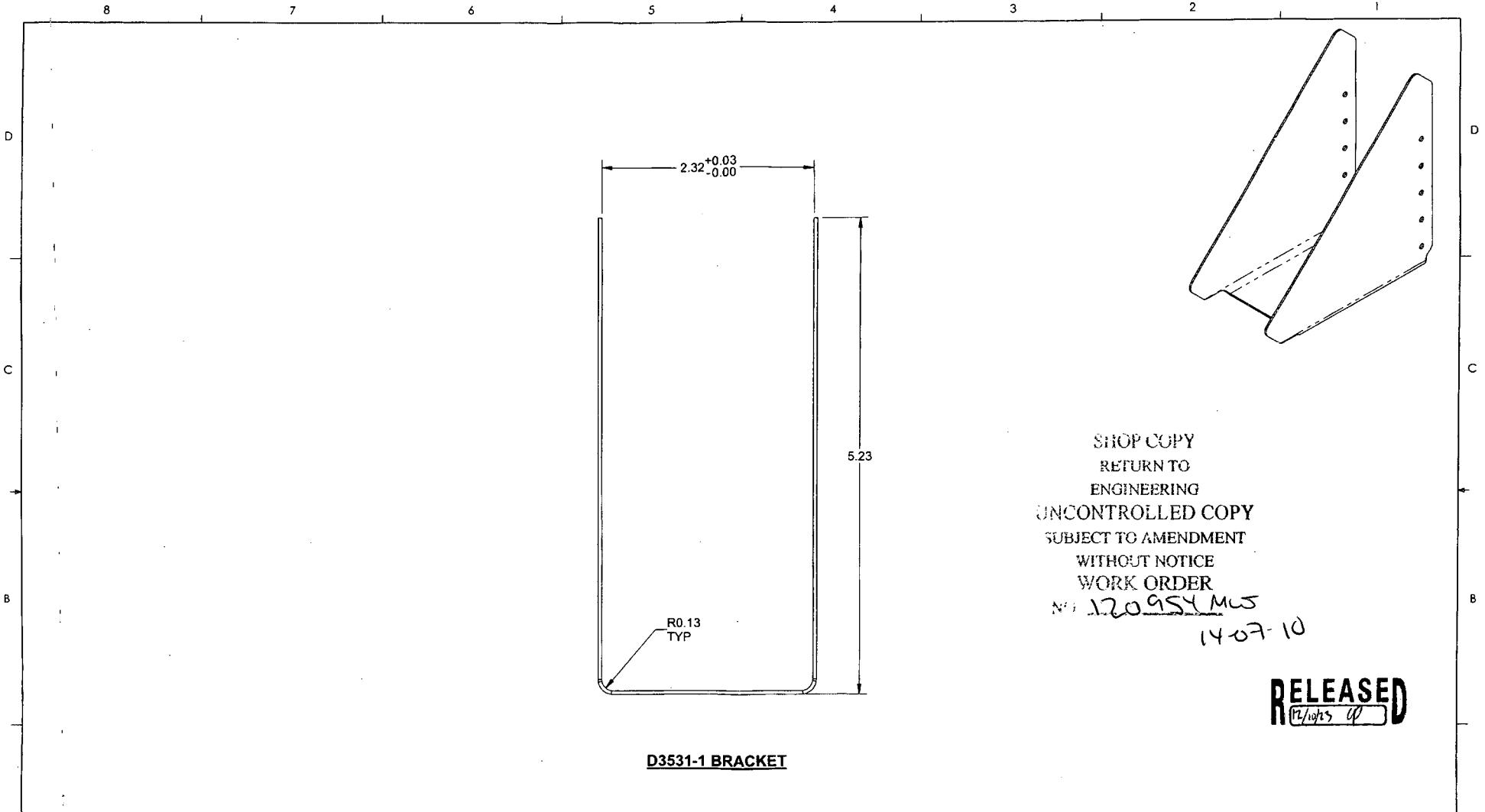
DSC
EST 1932

٣٧

Measured by:	mm	Audited by:	9-89	Preliminary Approval:	
Date:	14/07/18	Date:	14/7/18	Date:	

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	

8 7 6 5 4 3 2 1

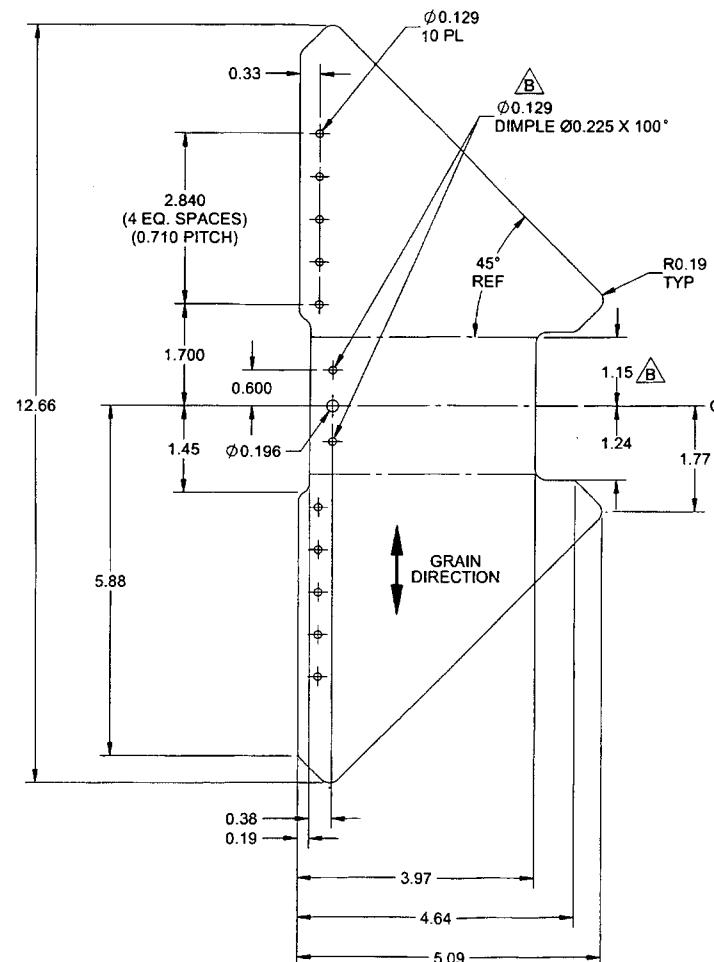


- NOTES:
- 1) MATERIAL: MADE FROM D3531-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

DESIGN	CB	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	REV. B	
MFG. APPR.	AV	DRAWING NO.	
APPROVED	NP	D3531	SHEET 2 OF 5
DE APPR.	NP	TITLE	SCALE
DATE	12.08.09	BRACKET ASSEMBLY	

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.16 lbs

D3531-1F FLAT PATTERN

DESIGN	<i>CB</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>AV</i>	D3531	SHEET 3 OF 3
APPROVED	<i>MR</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	BRACKET ASSEMBLY	
DATE	12.08.09	NTS	

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD.
IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

8

7

6

5

4

3

3

1

A